



Dart Aerospace Ltd.
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D3639-1

Job Sheet 192301



Part No: D3639-1

Job Qty: 4 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/21/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		4/12/19	0.00	0.30	Waterjet - Flow		02/19/07/19
110	QC 2	4 pcs		4/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		02/19/07/19
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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120 QC 8	4 pcs	4/12/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS JUL 19 2019 40 9-89
				QC 8 - 52	
				QC 8 - 23	
130 Small Fab - Brake NC - B4B	4 pcs	4/12/19	0.06 0.19	Small Fab - Brake - 1 - B4B	DAS 30 9-89 JUL 23 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	4 pcs	4/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS JUL 24 2019 40 9-89
150 Handfinish - 1-1 Chemical-B4B	4 pcs	4/12/19	0.00 0.25	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUL 24 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	

				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160	QC 7	4	4/12/19	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
170	Packaging 3-1 - Stock - B4B	4	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B

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				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21 JUL 24 2019
				QC 21 - SA - 53	5-55
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Chemical Conversion Coat per QSI005 4.1) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3S.050	2024-T3 .050 Sheet	.9560 sf (.239 ea)	100-Waterjet - Flow - 1	S167934	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.050	1	43	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	192301
Description: Doubler		Part Number:	D3639-1
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0.624	1		Visual	
Ø0.191	+0.005/-0.001	0.192	1			
Ø0.098	+0.004/-0.001	0.099	1			
0.69	+/-0.030	0.69	1			
1.59	+/-0.030	1.59	1			
2.49	+/-0.030	2.50	1			
3.39	+/-0.030	3.37	1			
3.990	+/-0.010	3.992	1			
4.990	+/-0.010	4.994	1			
5.19	+/-0.030	5.20	1			
6.99	+/-0.030	6.97	1			
8.64	+/-0.030	8.66	1			
0.45	+/-0.030	0.45	1			
0.710	+/-0.010	0.713	1			
2.000	+/-0.010	2.004	1			
2.75	+/-0.030	2.76	1			
3.55	+/-0.030	3.55	1			
4.00	+/-0.030	4.00	1			
2.000	+/-0.010	2.003	1			
2.590	+/-0.010	2.593	1			

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Measured by:	an	Audited by:	DAS 40 9-89	Prototype Approval:	N/A
Date:	19/07/18	Date:	JUL 19 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

Container No: S199095



Part: D3639-1

Job No: 192301

Serial No/Batch: S199095

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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